

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019561**Date Inspected:** 10-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path

PCMK: BK004A8-026

Weld No. 070,078

Tack Welder: 040302

WPS-B-T-2132

Heat straightening of PCMK, BK004A6-032 under approved Heat Straightening procedure, HSR1(B)-9015. The in process temperature was observed as 230°C. The ZPMC QC was identified as Li Jun. The approved HSR procedure stated that a maximum temperature of 650°C with 1~3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 6mm.

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This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path

PCMK: BK004A3-026

Weld No. 064,065,067,068

Tack Welder: 500363

WPS-B-T-2114

Component; Bike Path

PCMK: BK004A3-026

Weld No. 103,104,105

Tack Welder: 056200

WPS-B-T-2114

Bay 11

This QA Inspector observed the following work in progress for Bay 11.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Mao Bin Bin, CWI Zhao Chen Sun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Tower Lift 5, suspender bracket

PCMK: SD1-BRSA5-1-6B

Weld No. 6

Welder: 044541

WPS-B-T-3213-TC-U5b

Component; Tower Lift 5, suspender bracket

PCMK: ND1-BRSA5-2-15B

Weld No. 15

Welder: 040724

WPS-B-T-3213-TC-U5b

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ming Yang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

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Component; OBG 13AW
PCMK: SEG3013N
Weld No. 096,101,106,111,116,121,126
Tack Welder: 201215
WPS-B-T-2233-TC-U4b-1

Component; OBG 13BW
PCMK: SEQ3014P
Weld No. 047,075,076,079
Tack Welder: 045280
WPS-B-T-2233-TC-U4b-F

Component; OBG 13BW,
PCMK: SEG3019AP
Weld No. 005
Tack Welder: 048924
Repair No. B-WR16357
WPS-345-FCAW-1G(1F)-Repair-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
